

Work Order ID 134761

Monday, July 20, 2015 10:06:17 AM

134761

Page 1

Item ID: D5194-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Doubler
Start Date: 7/20/2015 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 7/20/2015 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: MLS Date: JUL 20 2015 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5194	A								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: <u>A</u> Prog Rev: <u>A</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
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9-89

JUL 21 2015

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Item ID: D5194-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Doubler

Start Date: 7/20/2015 Start Qty: 10.00

10

Cust Item ID:

Required Date: 7/20/2015 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1 NC BRAKE	0.00							
130									
HandFinish	Memo	0.00							
Hand Finishing									
140	QC7-Inspect Chemical Conversion Coat	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	Identify as per dwg & Stock Location: <u>St228A</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging									

15-7-23

(12)

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JUL 23 2015

JUL 23 2015

DAS
6
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Item ID: D5194-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Doubler

Stop

NS2

Start Date: 7/20/2015 Start Qty: 10.00

10

Cust Item ID:

Required Date: 7/20/2015 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

ML5

JUL 24 2015

SA 20150723

ML5

JUL 24 2015

Picklist Print

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Work Order ID: 134761

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Parent Item: D5194-1

D5194-1

Parent Item Name: Doubler

Start Date: 7/20/2015

Required Date: 7/20/2015

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 14.12.03 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased			No		sf	265.9213		6.863158			

M6061T6S 032

6061-T6 Sheet 0.032"

07/15/20

Location

Loc Qty

Loc Code

MAT021

265.9213

m130387

26.5667

m130522

19.6546

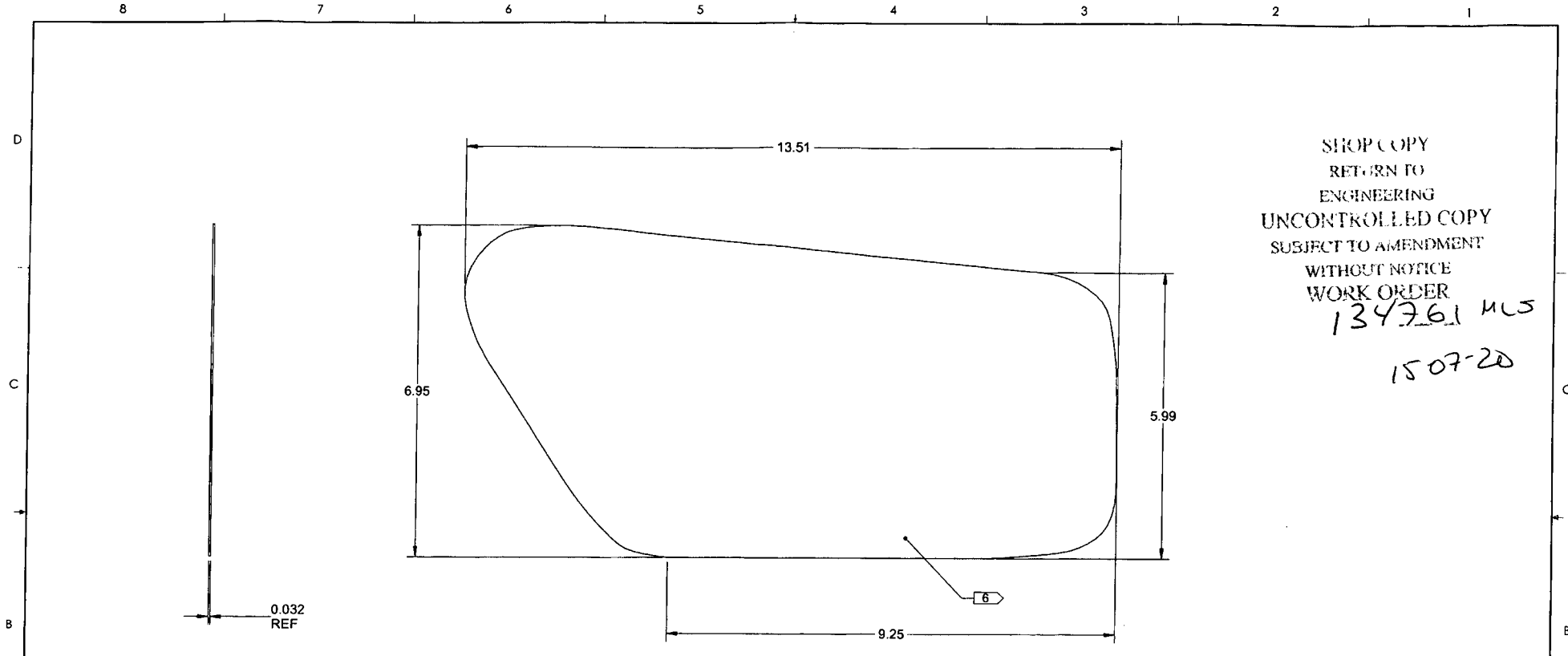
m131352

75.7

m132772

144

9.5



SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 134761 MLC
 1507-20

D5194-1 DOUBLER

RELEASED

2015 APR 30

47 ECN 15-527

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.032 THICK
 PER QQ-A-250/11 OR AMS-QQ-A-250/11
 OR AMS 4025 OR AMS 4027
 OR ASTM B209
 REF DART SPEC M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.24 lbs
- 8) CUT PER D5194-1.DXF. NON-DIMENSIONED FEATURES CONTROLLED BY D5194-1.SLDPRT

APPROVED	A NEW ISSUE		AK	14.11.20
	REV.	DESCRIPTION	BY	DATE
	DESIGN	AK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	AK		
	CHECKED	RF	DRAWING NO.	REV. A
	MFG. APPR.	DD	D5194	SHEET 1 OF 1
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	DOUBLER	NTS
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